

\*Date: Wednesday, 29/04/2009 3:00:34 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUAL CARGO MIRROR ASS'Y  
 Job Number : 47594  
 Estimate Number : 13191  
 P.O. Number :  
 This Issue : 29/04/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D119696043  
 First Issue : 1/1 Type : SMALL /MED FAB Drawing Number : D3074 U/R/ICA P19,21  
 Previous Run : 38287 Drawing Revision : A2/0 PH 09.04.30  
 Material :  
 Due Date : 10/05/2009 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : 09.04.29  
 Comment : Est Rev:A 08-02-19 New issue DD verified by: LL

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W  
 049W



Comment: Qty.: 3.4997 f(s)/Unit Total : 13.9986 f(s)

304 RD Tube .500 x .035W

Material: AISI 304/316 SS tube Ø 0.50 x 0.035" wall

Batch M140968

2.0 D2054 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing - Delrin

batch B39433

FF 09-05-08

3.0 D2055 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Clamp

batch B34365

FF 09-05-08

4.0 D2056 Bell Crank



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bell Crank Assembly

batch B45542

FF 09-05-08

5.0 D30721 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket

batch 37635

FF 09-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.04.30	1	CHANGE THICKNESS OF MAT'L TO 0.049" WALL. 304 ROUNDTUBING M304TRO500W049 OBVIOUS STRENGTH IMPROVEMENT	RA	09.04.30	ALL	RA Q SE 042 09.04.30	5 09/05/14

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:00:35 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL CARGO MIRROR ASS'Y

Job Number: 47594

Part Number: D119696043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30722

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket

batch

37636

FF 09-05-08

4

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- punch one side

2- slide parts in tube

3- punch other side

4- bend as per dwg D3074

5- drill holes as per dwg D3074

6- deburr and polish

FF 09-05-08

4

FF 09-05-08

4

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/05/11

9.0

D2011101

6" Mirror



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mirror 6"

batch

B47592

FF 09-05-12

4

10.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

batch

m110905 x 2 / m111279 x 22

FF 09-05-12

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 3:00:35 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL CARGO MIRROR ASSY

Job Number: 47594

Part Number: D119696043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

batch 17 110844

FF 09-05-12

(3)

12.0

MS27039118

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

batch M 108161

FF 09-05-12

(4)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3074

FF 09-05-12

(4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-05-12 (4)

09/05/12 (xx)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 47482

09/05/13 (4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/13 (4)

Job Completion



MF  
09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

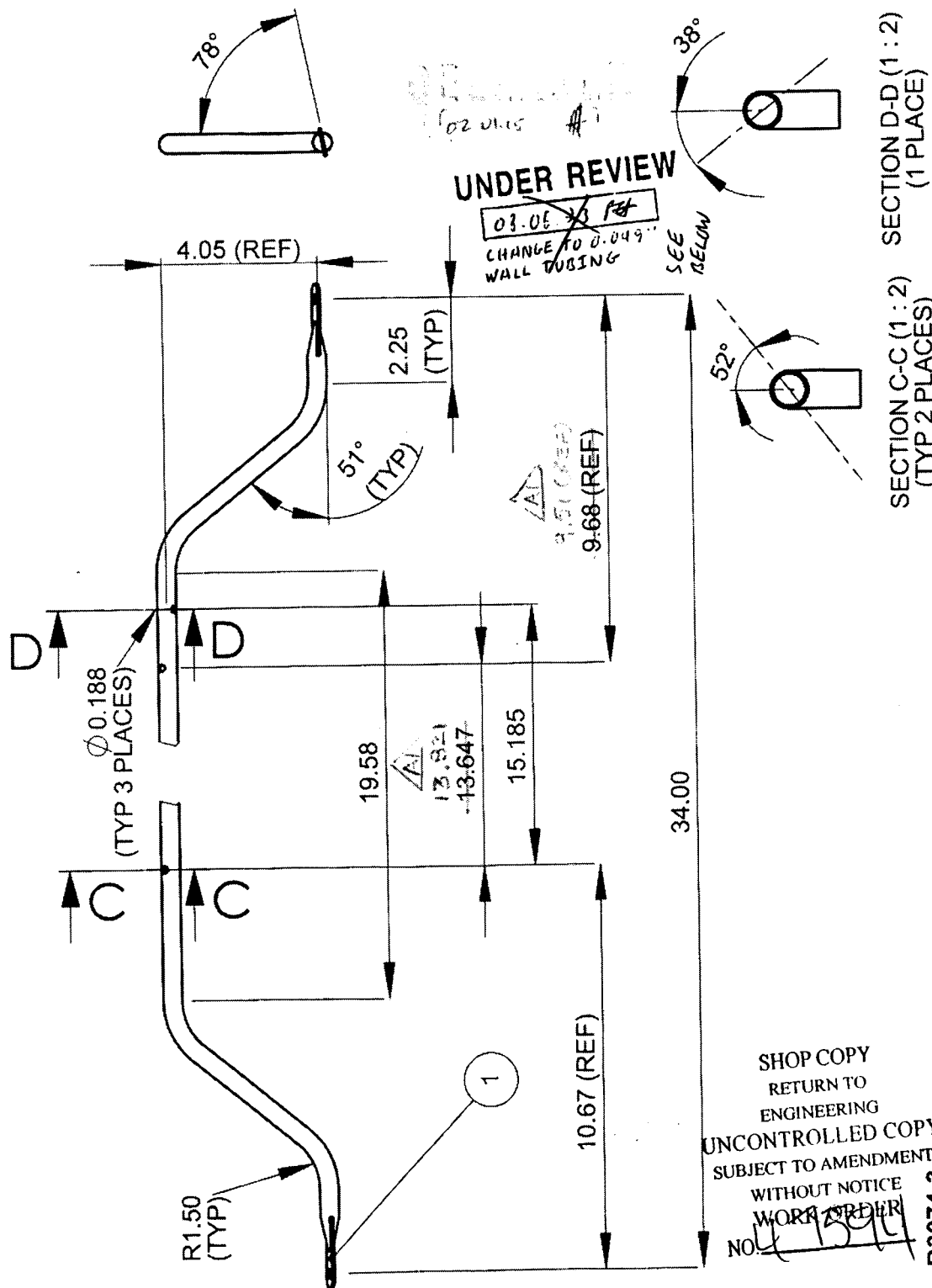
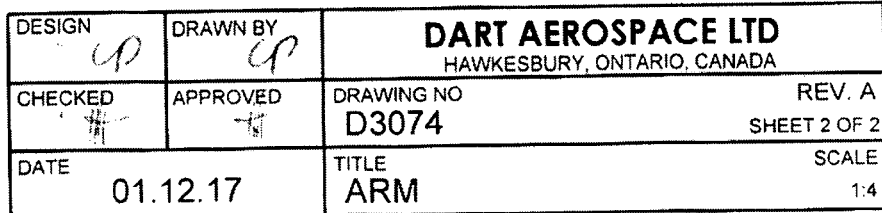
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



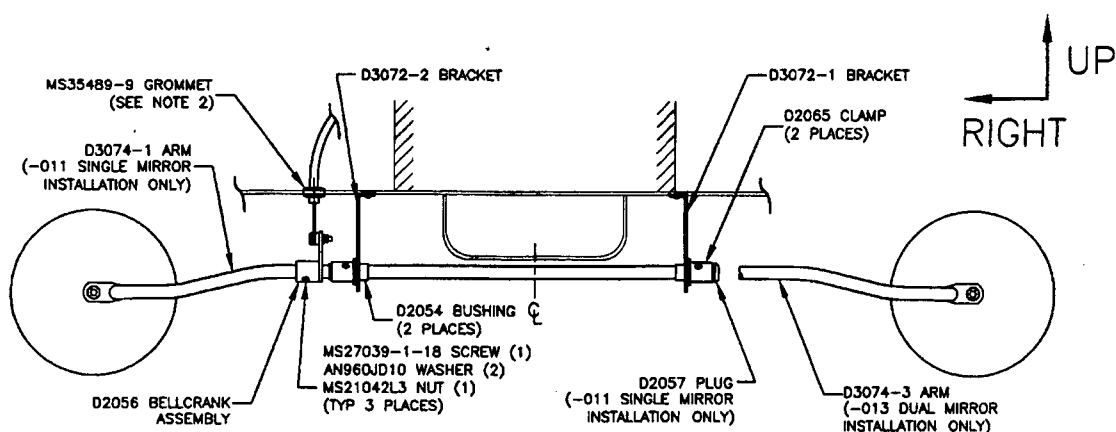


1) PUNCH ENDS PER SPEC CONTROL DRAWING D2727  
2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\phi 0.50 \times \phi 0.035$  WALL  
ENSURE SEAMLESS TUBING IS USED  
3) TOLERANCES ARE PER PART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) PART IS NOT SYMMETRIC

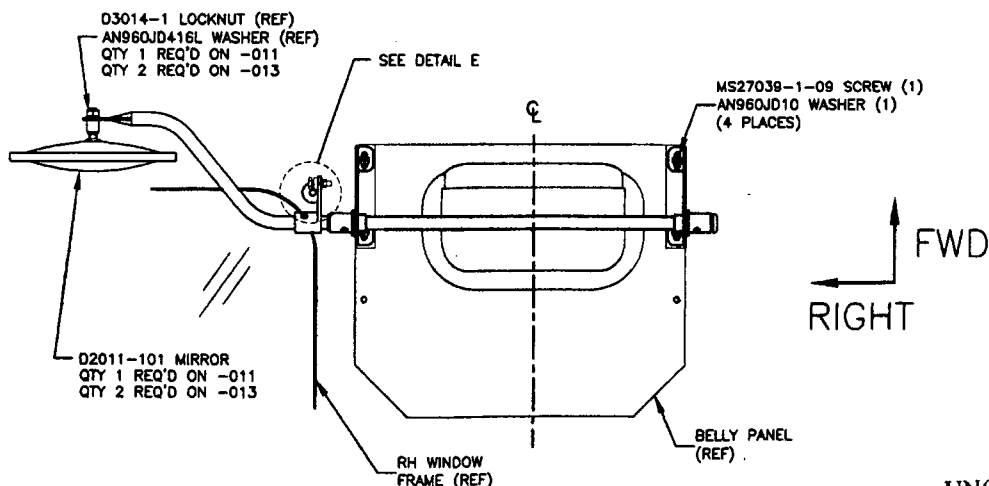
**COPYRIGHT © 2001 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





**Figure 25-2 – View A: Looking Aft**  
(D119-696-011/-013 Mirror Shown)



**Figure 25-3 – View B: Looking Up**  
(D119-696-011 Mirror Shown, -013 similar)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 111594

• COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

**25-00-00**

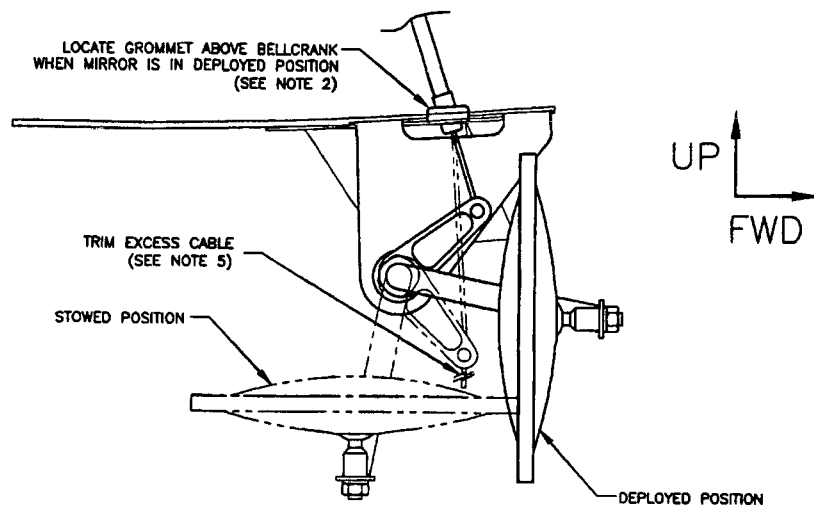


Figure 25-4 – Detail C: Side View of Mirror Deployment  
(D119-696-011/013 Mirror Shown)

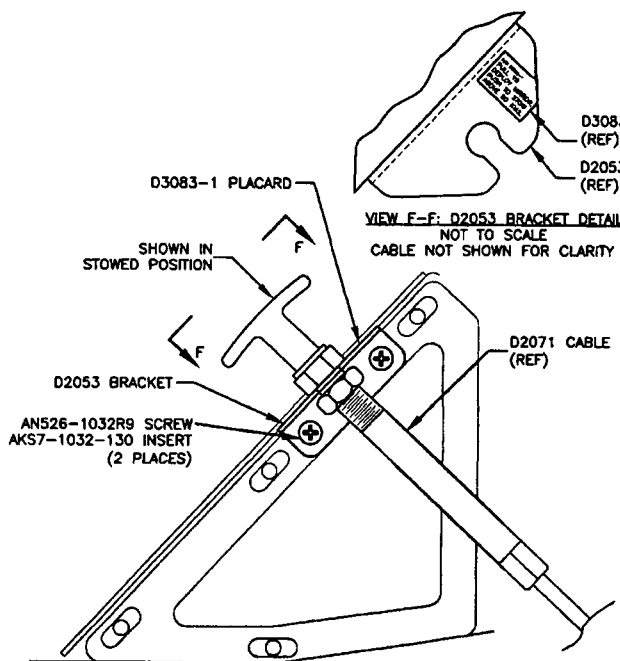


Figure 25-5 – Detail D  
Control Panel Attachment  
(D119-696-011/013 Mirror Shown)

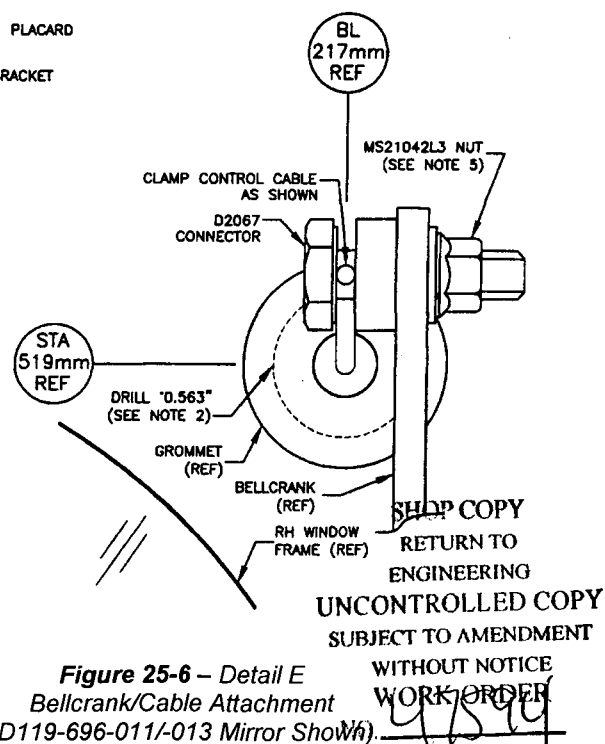


Figure 25-6 – Detail E  
Bellcrank/Cable Attachment  
(D119-696-011/013 Mirror Shown)

• COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.